



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G02331-3G-03

Job Sheet 171549



Part No: RBW6405G02331-3G-03

Job Qty: 4 ea *4*

Part Name: Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G02331-3G-03 REV:2 IPP REV A 18.01.19 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	2/8/18	2/8/18	0.00	0.00	Start Up Waterjet2		<i>du 18/03/05</i>
100	Waterjet	2 pcs	2/8/18	2/8/18	0.08	0.29	Waterjet 2 OMAX		<i>du 18/03/05</i>
110	QC	2 pcs	2/8/18	2/8/18	0.00	0.00	QC2 Waterjet-4		<i>du 18/03/05</i>
120	Mori Seiki	2 pcs	2/8/18	2/8/18	2.50	1.00	MORI NV5000-1		<i>du 18/03/03</i>
130	QC	2 pcs	2/8/18	2/8/18	0.00	0.00	QC2 Machining-5		<i>du 18/03/13</i>
135	Mill Conv	2 pcs	2/9/18	2/9/18	0.00	0.50	Mill Conv 2		<i>du 18/03/13</i>
140	QC	2 pcs	2/9/18	2/9/18	0.00	0.00	QC2 Machining-3		<i>du 18/03/13</i>
150	QC	2 pcs	2/9/18	2/9/18	0.00	0.00	QC8 Machining-5		<i>B = 18-03-15</i>
200	Outsource	2 pcs	2/9/18	2/9/18	0.00	0.00	Outsource13		<i>CT 3/16/18</i>
210	Packaging	2 pcs	2/9/18	2/9/18	0.00	0.00	Packaging2		<i>AT 18/03/14</i>
220	QC	2 pcs	2/9/18	2/9/18	0.00	0.00	QC6		<i>38</i>
230	Packaging	2 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3-2	<i>DAS</i>	<i>9-89</i>
240	QC21-SA	2 Ea	2/9/18	2/9/18	0.00	0.00	QC21	<i>21</i>	<i>MAR 27 2018</i>

Part Op 120 - 1-Machine as per folio FB 933 FOLIO REV: _____ DWG REV: 9-80 2-Deburr 3-

Descriptions: Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

135 - -Drill lockwire holes as per dwg.

200 - -Issue P/O to Groupe Altech: P/O P0039336 -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required

210 - Receive

230 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.000X6.250	4140 Steel Bar 1.000 X 6.250	.5820 ft (.291 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-1.000X6.250	1	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S048023

Part: RBW6405G02331-36-03

Job No: 171549

Serial No/Batch: S048023

Revision: 2

Inspector:

Date: 03/06/18

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Hemel Hempstead, UK
Hemel Hempstead, UK
Tel: +44 (0)1462 432400
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



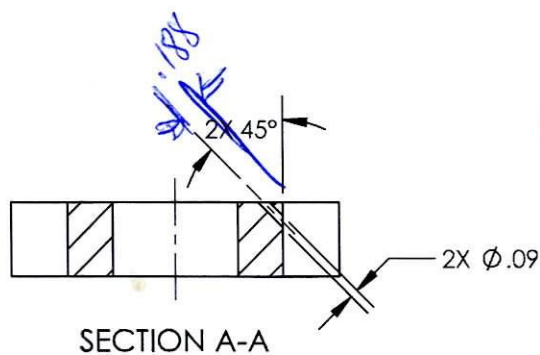
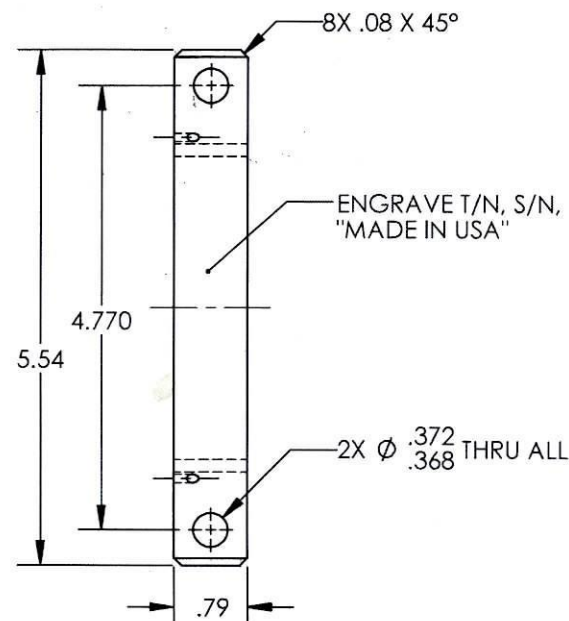
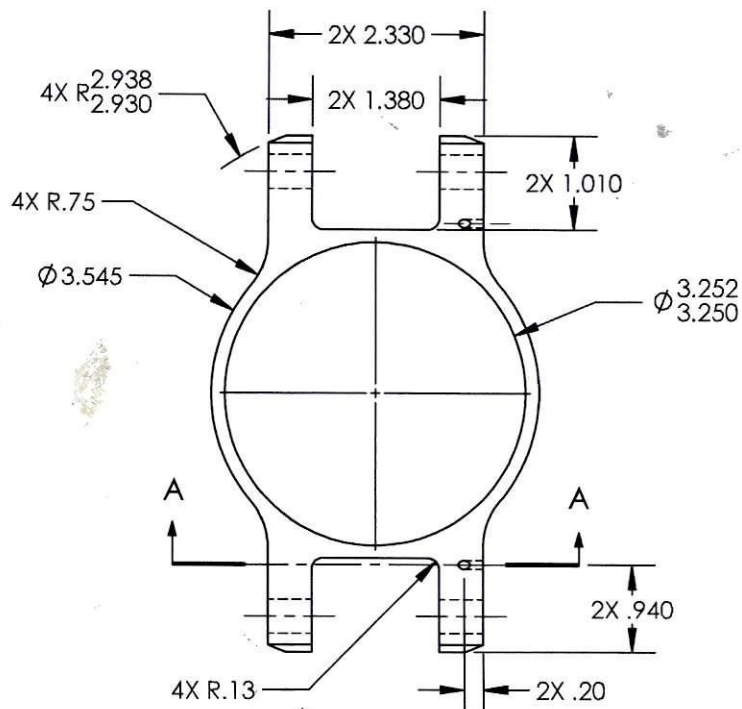
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0032	-03 CH'D ENGRAVE NOTE WAS ENGRAVE T/N "RBW6405G02331-3G", S/N, "MADE IN USA" IS ENGRAVE T/N, S/N, "MADE IN USA". CH'D MATERIAL WAS 4140 IS 4140/4142. CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC. ASTM B633 TYPE I SC2. ADDED HEAT TREAT RC 28-34.	1/26/2017	RJC	SM



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171545m

(-03)

FRAME



T/R UPPER CONICAL RING PULLER

DWG NO. RBW6405G02331-3G-03

REV
2

MATL 4140/4142

HEAT TREAT RC 28-34

TREAT	NO. 27-1
FINISH	ZINC PLATE

SPEC	ASTM B633 TYPE I SC 2
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DRAWN BY:	CLOUGH
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CHECKED:	DUERFFELDT
----------	------------

OPPS APPR:	ANDERSON
------------	----------

QA APPR:	LINDSAY
----------	---------

APPROVED:	LINDSAY MACKOVJAK
-----------	----------------------

SCALE		1:2	DATE
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1:2

DATE	3/25/2010
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SHEET 3 OF 9

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
XX $\pm .005$ FRACTIONS $\pm 1/8$
X $\pm .01$ ANGLES $\pm 5^\circ$
 $\pm .1$ SURFACES = 125/

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Traveller Change Request

Part#: RBW6405602331-3603

Job#: 171549

Name Mathieu Lamarche

Date 18/03/13

Workcenter CNC

Operation # 100 - 110

Issue: Quality ☐

Wrong Routing ☒

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: Remove water jet 20MAX and QC2
water jet-4. More easy to start from scratch and
faster.

Name _____

Date _____

Workcenter _____

Operation # _____

Issue: Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Name _____

Date _____

Workcenter _____

Operation # _____

Issue: Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039336**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039336
PO Date: 3/16/18
Due Date: 3/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171549	RBW6405G02331-3G-03	Frame -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	3/29/18	4 pcs ✓	0 pcs 4x	4 pcs At 18/03/18	\$22.50/pcs	\$90.00
Grand Total:										\$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/19/18 2:31 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(007675-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007675- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Mar-2018		Aman		P0039336				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6405G02331-3G-03 Rev.	RBW6405G02331-3G-03 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] ASTM B633 TYPE 1 SC2	ZINC CH	4	14	0	0	0

 DAB
 38
 9-88

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.